



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5499-1
Job Sheet 196099



Part No: D5499-1

Job Qty: 20 pcs

Part Name: Aft Bracket Mount



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/6/19

Job Tracking No:

Due Date: 7/5/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: D5499-1 REV.B IPP REV.A NEW ISSUE 18/04/26 JFS VERIFIED BY:DD IPP REV:B 18/08/03 AS PER DWG
REV.B JFS VERF BY:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	HAAS 5 Axis	20 pcs		7/5/19	0.50	14.99	HAAS - 5		19-06-30 / Fmk
120	QC 2	20 pcs		7/5/19	0.00	0.00	QC 2 - 1		19/07/01 / Fmk
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		19/04/30
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Container No: S196295



Part: D5499-1

Job No: 196099

Serial No/Batch: S196295

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/

Dart Aerospace Ltd.
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CANADA
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www.dartaerospace.com

6/6/2019,		[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie				
130 QC 8	20 pcs	7/5/19	0.00	0.00	QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	mon L 19/6/2019
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
140 Handfinish - 1-1 Chemical-B4B	20 pcs	7/5/19	0.00	1.67	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	SA JUL 09 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	

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				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	20 pcs	7/5/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
180 Packaging 3-1 - Stock - B4B	20 pcs	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	

DAS
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9-89

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PC GATPD

				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	20 pcs	7/5/19	0.00 0.00	QC 21 - SA - 21	<i>DAS</i>
				QC 21 - SA - 70	<i>21</i> JUL 10 2019
				QC 21 - SA - 53	<i>8-85</i>
Part Op 110 - (HAAS CNC vertical machine #5), 1-Machine per folio FC024. DWG REV: <i>B</i> FOLIO REV: <i>AA</i> 2-					
Descriptions: Deburr and break all sharp edges. <i>cut blank at 4.875</i>					
120 - (QC2- Inspect parts off machine FAI/FAIB)					
130 - (QC8- Inspect parts - second check)					
140 - (Chemical Conversion Coat per QSI005 4.1)					
150 - (QC7-Inspect Chemical Conversion Coat)					
180 - (Identify as per dwg & Stock Location:_____)					
190 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M8061T6B3.500X03.500	6061-T6 Bar 3.5" X 3.5" (Cut To 6 ft)	8.1400 ft (.407 ea)	110-HAAS 5 Axis	<i>5191233</i>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-HAAS 5 Axis	M8061T6B3.500X03.500	8	0	0	
Part Specifications					
Specifications could not be found					

*Give chemical
for order*

*MAT
used
8.2001*

se.marie

DART AEROSPACE LTD		Work Order:	196099
Description: AFT BRACKET MOUNT		Part Number:	D5499-1
Inspection Dwg: D5499	Rev: B	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.69	+/-0.030	0.690	✓		H-6	31006
0.33	+/-0.030	0.325	✓		Vern	GA-13
R0.13	+/-0.030	R0.125	✓		R-6	ref.
R0.13	+/-0.030	R0.125	✓		"	"
R0.42	+/-0.030	R0.420	✓		"	"
1.500	+/-0.010	1.500	✓		Vern	GA-13
0.623	+/-0.010	0.619	✓		Dial ind.	HAAS 5
φ0.191	+0.005 /-0.001	φ0.193	✓		Vern	GA-13
1.250	+0.010 /-0.000	1.250	✓		H-6	31006
φ0.257	+0.006 /-0.001	φ0.258	✓		Vern	GA-13
0.80	+/-0.030	0.803	✓		"	"
0.40	+/-0.030	0.3985	✓		"	"
2.49	+/-0.030	2.488	✓		"	"
1.92	+/-0.030	1.915	✓		H-6	31006
0.343	+0.005 /-0.000	0.343	✓		Vern	GA-13
0.80	+/-0.030	0.799	✓		"	"
R0.13	+/-0.030	R0.125	✓		R-6	ref.
3.506	+/-0.010	3.505	✓		H-6	31006
1.337	+/-0.005	1.3385	✓		"	"
1.50	+/-0.030	1.499	✓		Vern	GA-13
1.245	+0.000 /-0.010	1.243	✓		Mic	GA-02
R0.25	+/-0.030	R0.250	✓		R-6	ref.
2.65	+/-0.030	2.650	✓		Vern	GA-13
4.66	+/-0.030	4.655	✓		"	"
0.623	+/-0.010	0.6218	✓		Dial ind.	HAAS 5
0.13 X 45°	+/-0.030 X +/-0.010	0.125 X 45°	✓		Vern	GA-13
φ0.191	+0.005 /-0.001	φ0.192	✓		"	"
R0.13	+/-0.030	R0.125	✓		R-6	ref.
0.760	+/-0.005	0.760	✓		H-6	31006

Measured by: B.A.	Checked by: mm.l.	QC Inspector:
Date: 19-06-30	Date: 19/07/09	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

Entered:

Date: 19-07-03

mid 26 July 2019



NCR No.

19- 7348

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

Job: 196 099		DISPOSITION		DEPARTMENT/PROCESS				Route update only			
Part No. 05499-1		Rework ☐ Scrap ☒ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☒ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐							
Date: 19-07-03	Sequence #: 110	QTY Affected: 2		MRB (QS1042)		Completed By					
Description Work Order Deviation		Disposition		Scrap & Replace B# S191233				Lead hand / Supervisor			
								B-a 19-07-05			
The machine ran out of air pressure causing one axis to plunge into the part with the endmill		Root Cause		FAULT CATEGORY							
				Pressure/Forced		Contamination		Power Loss/Surge		Positioned Wrong	
☐ Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors		☐ Bending		☐ Misaligned/off center		☐ Folio/Program		☐ Outside Tolerance			
		☐ Crushing		☐ BOM/Route		☐ Grain Direction		☐ Drawing			
		☐ Cracks		☐ Broken/Damage/Defect		☐ Weld		☐ Finish			
		☐ Crimp/Kink/Ripple/Wave/Twist		☐ Incomplete/Unclear Instructions		☐ Wrong Stock Pulled		☐ Part Lost/Missing			
		☒ Marks/Chatter		☐ Drill Holes		☐ Out of Sequence		☐ Misread			
		☐ Mislabeled		☐ Fit/Function		☐ Off-set/Set-up					
		Other/Details:									